

Date: Wednesday, 08/04/2009 10:50:44 AM  
 User: Melanie Fauteux

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: FWD BLADE FOLD ASSEMBLY
<b>Job Number</b>	: 47091		
<b>Estimate Number</b>	: 13531		
<b>P.O. Number</b>	:	<b>Part Number</b>	: PB674300101
<b>This Issue</b>	: 08/04/2009	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: B6743001 P.1, 2
<b>First Issue</b>	: / /	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 45644	<b>Drawing Revision</b>	: B1
	<b>Type</b> : SMALL / MED FAB	<b>Material</b>	:
<b>Written By</b>	:	<b>Due Date</b>	: 29/04/2009
<b>Checked &amp; Approved By</b>	: <u>MF 09-04-08</u>	<b>Qty:</b>	1
<b>Comment</b>	Est Rev:A 08-07-30 new issue DD verified by:ec Est Rev:B 08-12-04 up date part list DD Verified by:ec		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	PB674300107	Fwd Blade Fold Assembly Weldment
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Fwd Blade Fold Assembly Weldment

batch: B47088

Pl09-05-06

2.0	PB674300115	Fwf Adjustable Blade Support Assembly
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Fwf Adjustable Blade Support Assembly

batch: B47052

Pl09-05-06

3.0	PB674300111	Fwf Adjustable Blade Support Assembly
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Fwf Adjustable Blade Support Assembly

batch: 47050

Pl09-05-06

4.0	PB674300121	PB67-43001-21
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

PB67-43001-21

batch: B47054

Pl09-05-06

5.0	PB674300123	PB67-43001-23
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

PB67-43001-23

batch: B47055

Pl09-05-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: FWD BLADE FOLD ASSEMBLY

Job Number: 47091

Part Number: PB674300101

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PB674300145

Longitudinal Support Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Longitudinal Support Assembly

batch: 46028

MF 09-04-28

7.0

PB674300151

Long T-Handle Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Long T-Handle Assembly

batch: 47058

MF 09-04-28

8.0

PB6743001261

Lever Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Lever Arm

batch: 47094

MF 09-04-28

9.0

PB6743001265

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bushing

batch: 46932

MF 09-04-28

10.0

PB6743001299

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bushing

batch: 43094

MF 09-04-28

11.0

D3451041

Handle and Lock-Down Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle and Lock-Down Assembly

batch: 47045

MF 09-04-28

12.0

D3451047

Handle and Lock-Down Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle and Lock-Down Assembly

batch: B 47048

MF 09-04-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: FWD BLADE FOLD ASSEMBLY

Job Number: 47091

Part Number: PB674300101

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D34473

Square Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Square Spacer

batch: 4741351

MF 09-04-28

14.0

D34477

Clevis



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Clevis

batch: 47117

MF 09-04-28

15.0

D34479

Swing Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Swing Arm

batch: 46263

MF 09-04-28

16.0

D3445041

Belt Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Belt Assembly

batch: 46264

MF 09-04-28

17.0

086004

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Inventory

batch: M109350

MF 09-04-28

18.0

MS27039104

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Inventory

batch: M18431

MF 09-04-28

19.0

MS27039123

SCREW



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SCREW

batch: M18051

MF 09-04-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 47091

Part Number: PB674300101

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: m110844

mf 09-04-28

21.0

MS21042L4

Nut



Comment: Qty.: ~~10.0000~~ <sup>8</sup> Each(s)/Unit Total : ~~10.0000~~ <sup>8</sup> Each(s)

Nut

batch: m110450 → NEED 8

mf 09-04-28

22.0

MS21042L6

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

batch: m110002

mf 09-04-28

23.0

MS518596

WASHER



Comment: Qty.: ~~8.0000~~ <sup>4</sup> Each(s)/Unit Total : ~~8.0000~~ <sup>4</sup> Each(s)

WASHER

batch: m108473 → NEED 4

mf 09-04-28

24.0

MS518598

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

batch: m108987 → 8

or MS51859-7 (see engineering) batch: m110193 → 4

mf 09-04-28

25.0

NAS43DD368

SPACER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SPACER

batch: m110983

mf 09-02-28

26.0

NAS1149F0316P

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

WASHER

batch: m11117

mf 09-04-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 47091

Part Number: PB674300101

Job Number:



Seq. #:	Machine Or Operation:	Description :
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27.0	NAS1149F0432P	Washer
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Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Washer

batch: M18057

MF 09-04-28

28.0	NAS1149F0632P	WASHER
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

batch: M18057

MF 09-04-28

29.0	NAS1149F0832P	WASHER
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

WASHER

batch: M18057

MF 09-04-28

30.0	AN960JD6	Washer
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Comment: Qty.: 52 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: M6085

MF 09-04-28

31.0	AN410A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: M108986

MF 09-04-28

32.0	AN413A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: M110731

MF 09-04-28

33.0	<del>AN410A</del>	Bolt
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

batch: \_\_\_\_\_  
or AN415A (see engineering) batch: M110399

MF 09-04-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 47091

Part Number: PB674300101

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

AN611A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

BOLT

batch: m105558 x1, m110155 x1

mf 09-04-28

35.0

~~AN020A~~

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: m111636  
or AN6116A (see engineering) batch:

pl09-05-06

36.0

AN813A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

BOLT

batch: m110915

mf 09-04-28

37.0

BSP43

RIVET



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

RIVET

batch: m109119

mf 09-04-28

38.0

CR3213405

cherry rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

cherry rivet

batch: m108473

mf 09-04-28

39.0

MS17984C408

PIN, QUICK RELEASE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

PIN, QUICK RELEASE

batch: m111279

or MS17984C410 (see engineering) batch:

mf 09-04-28

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: FWD BLADE FOLD ASSEMBLY

Job Number: 47091

Part Number: PB674300101

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

MS17984C418

PIN, QUICK RELEASE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

PIN, QUICK RELEASE

batch: 108991

MF 09-04-28

41.0

30345T22

8" LANYARD



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

8" LANYARD

batch: m 108390 xi, 108973 xi

MF 09-04-28

42.0

30345T24

LANYARDS



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

LANYARDS

batch: m 108973

MF 09-04-28

43.0

240107

SPRING SLOTTED PIN



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

SPRING SLOTTED PIN

batch: m 111088

MF 09-04-28

44.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per dwg and use 242 threadlock A/R shown on dwg PB67-43001 page 2.

242 THREADLOCK batch: m 109687

Pl 09-05-06 (1)

45.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/05/07 (X)

46.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PPP 47586

Pl 9/5/7 (1)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 47091

Part Number: PB674300101

Job Number:



Seq. #:

Machine Or Operation:

Description :

47.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/07

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-05-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

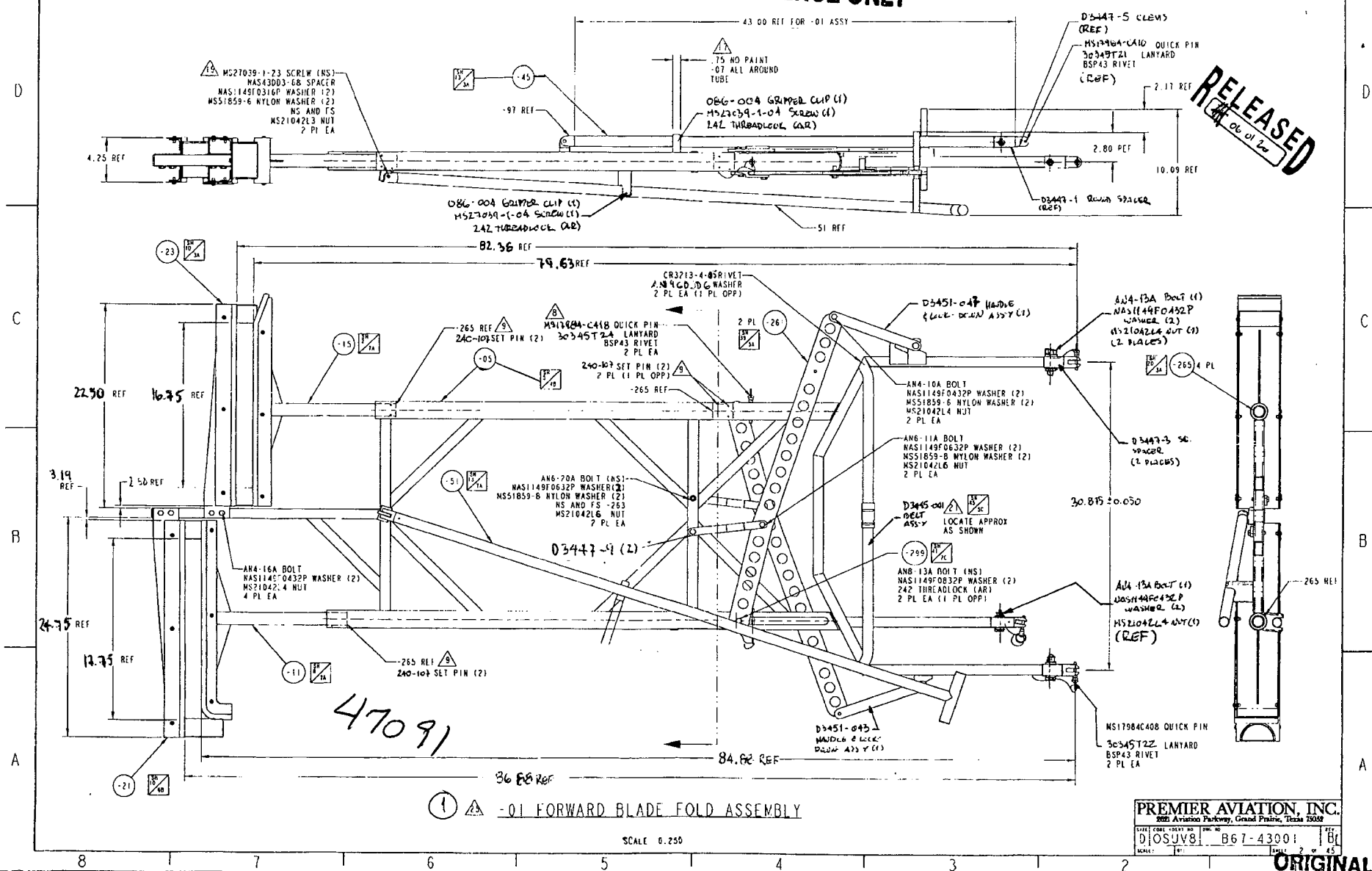
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**NOTE:** Date & initial all entries



**REFERENCE ONLY**



REF  
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REF

**RELEASED**  
# 06 01 200

**PREMIER AVIATION, INC.**  
2021 Aviation Parkway, Grand Prairie, Texas 75052

SIZE	CASE / DELT NO	QTY. NO	REV.
D	OSUV8	B67-43001	B6

SWELL 2 of 45  
**ORIGINAL**